

Work Order ID 59487

Friday, June 04, 2010 2:49:11 PM



Page 1

Item ID: D4001-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 6/4/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-6-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4001

A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

cut blank 4.200" long

DTT 10/6/14

4 0

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA912

FOLIO REV: A

DWG REV: A

DEBURR

MMK 10/06/15

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

MMK
10/06/15

4

Ø

Memo

0.00

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

SH 10/06/15

4

Ø

Memo

0.00

140



Packaging

Packaging

Identify as per dwg & Stock Location 114

0.00

Memo

0.00

106-77 SPS

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/21 *[Signature]*
MF
10-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 2:49:16 PM

Page 1

Work Order ID: 59487



Parent Item: D4001-1



Parent Item Name: Fitting

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPPP REV:A NEW ISSUE 10-02-22 JLM VERIFIED BY:EC IPP rev B
10.05.13 ecn10-562 EC verified by:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	78.5800	0.3501	1.474105			



6061-T6 Bar 1.00 x 4.00



Location

Loc Qty

Loc Code

MAT03

78.58

107221

58.58

114352

20

1,474(F)  10/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

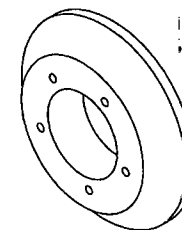
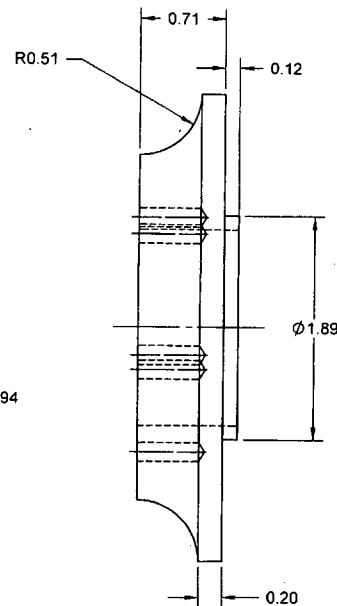
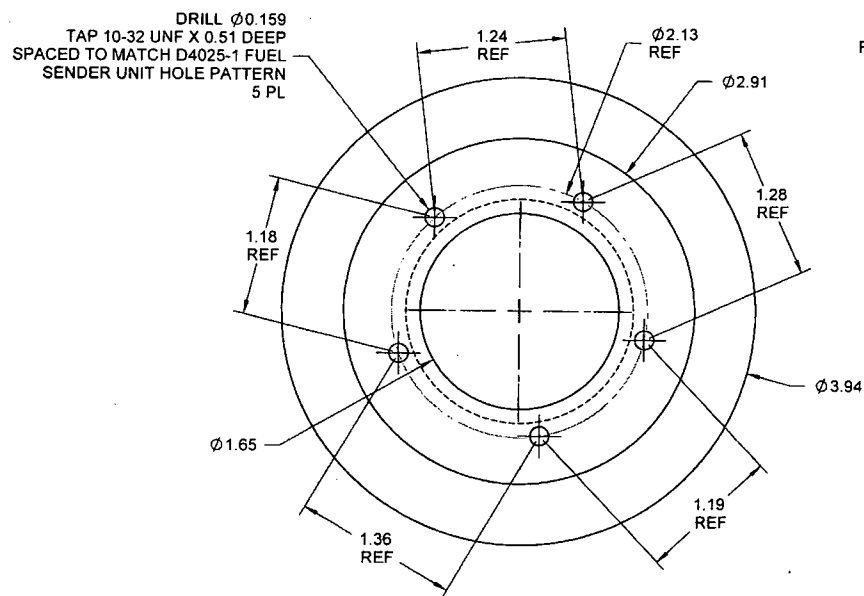
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NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-1	JCA-M47-1-08



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59487

10-6-07

RELEASED
2010-05-05

D4001-1 FITTING

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.02.05			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4001** REV. **A**
SHEET 1 OF 2
TITLE **FITTING** SCALE **NTS**

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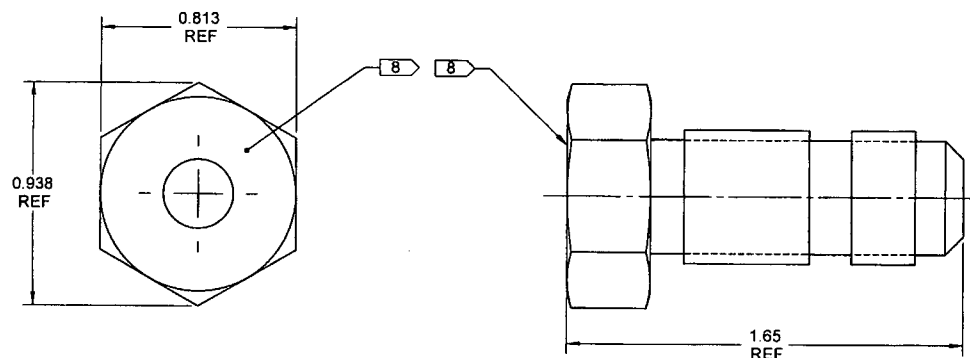
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-3	JCA-M47-2-28 (AN832-6D-JCA)

AN832-6D
BEFORE MODIFICATION
REF



D4001-3 FITTING

NOTES:

- 1) MATERIAL: MADE FROM AN832-6D
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs
- 8) BRUSH ALODINE MACHINED SURFACE

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4001
MFG. APPR.		REV. A
APPROVED		TITLE FITTING
DE APPR.		SCALE NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD

RELEASED
2010-05-05

W/0 59487

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